

Work Order ID 63301

Page 1

Wednesday, October 27, 2010 10:51:05 AM

Item ID: D212-725-1-091F

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 10/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MPDate: 10-10-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

F

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: FProg Rev: F

304 .032

2-Deburr if necessary

10-10-282

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	S 10/10/28			(+2)			
130  Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00	SB 10/10/29			(2)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 10/10/29			(+2)			

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Page 3

Item ID: D212-725-1-091F

Accept

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Revision ID:

Stop

Item Name: Angle

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 3&5

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/29/29 (2)

10/10/29

MF
10-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 10:51:09 AM

Page 1

Work Order ID: 63301



Parent Item: D212-725-1-091F



Parent Item Name: Angle


Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA  304/316 .032 Sheet		Purchased	No			100	sf	89.4896	0.4066	0.856			



1310-14-28

Location

Loc Qty

Loc Code

MAT20

89.4896

109023

30.2896

109057

59.2

109057

②

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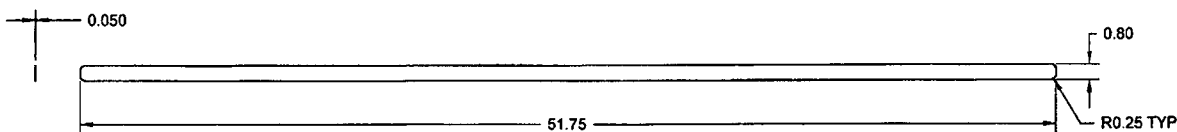
NOTE: Date & initial all entries

D212-725-1-041F

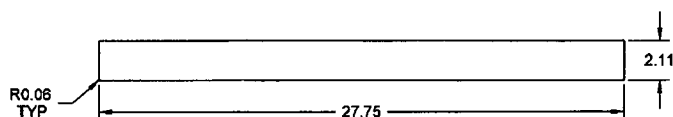
X	First Article	X	Prototype
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Measured by: <u>AB</u>	Audited by: <u>S</u>	Prototype Approval:
Date: <u>10-10-28</u>	Date: <u>10/10/28</u>	Date:

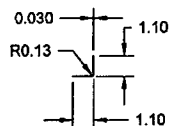
H:\FORMS\Quality Assurance\approved QA\FAI revD



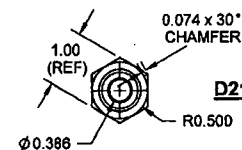
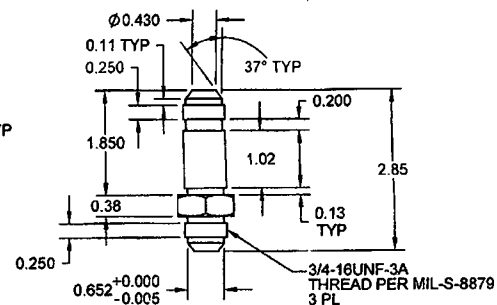
D212-725-1-089 STRAP



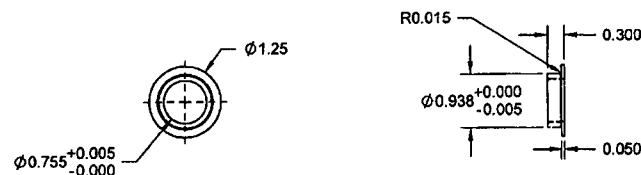
D212-725-1-091F FLAT PATTERN



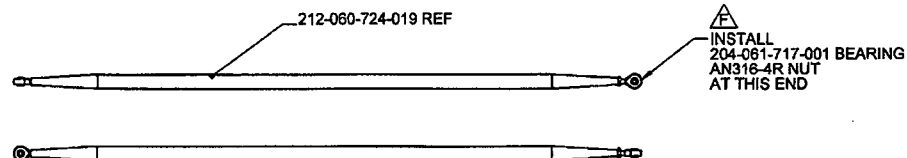
D212-725-1-091 ANGLE
(MAKE FROM D212-725-1-091F FLAT PATTERN)



D212-725-1-093 UNION
SCALE 2X



D212-725-1-105 BUSHING
SCALE 2X



D212-725-1-919 ROD ASSEMBLY
(MADE FROM 212-060-724-019)

D212-725-1-089 NOTES:
1) MATERIAL: AISI 301 STAINLESS STEEL 1/4 OR 1/2 HARD 0.050 (18 GAUGE) SHEET, PER AMS-5517-5518

D212-725-1-091 NOTES:
2) MATERIAL: AISI 304/316 STAINLESS STEEL 0.030 (22 GAUGE) SHEET, PER AMS-5513/-5524 (REF. DART SPEC. M304S22GA)

GENERAL NOTES:
3) FINISH: NONE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010
7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

D212-725-1-105 BUSHING:
1) MATERIAL: AISI 303/304/316 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M303R)

D212-725-1-093 UNION:
2) MATERIAL: AISI 303 STAINLESS STEEL HEX BAR (REF. DART SPEC. M303H)




GENERAL NOTES:
3) FINISH: NONE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010
7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

D212-725-1-919 NOTES:

- 1) MATERIAL: MADE FROM 212-060-724-019 TUBE ASSEMBLY
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 563301

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D212-725-1	SHEET 33 OF 84
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.02.02	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
01/01/11 MP

210-10-2-

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